

Date: Thursday, 19/02/2009 11:50:02 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 407 HIGH AFT X-TUBE ASSEMBLY
<b>Job Number</b> : 45893	
<b>Estimate Number</b> : 13208	
<b>P.O. Number</b> :	<b>Part Number</b> : D407667205TRN
<b>This Issue</b> : 19/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D407-667-245 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 43231	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/02/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.19</u>	
<b>Comment</b> : Est Rev:A 08-03-06 new issue DD verified by:ec Est Rev B 08.04.02 Removed polish EC verified by: DD Est Rev:C 08-08-19 revE as per dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6011115

Crosstube Material

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6011-115 Crosstube B 32307

Check OD = 2.750"; ID = 1.450"

a.m 09.02.230

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8531 on both ends as per Folio FA248

2-Turn first side as per Folio FA248

3- File transition lines smooth.

a.m 09.02.230

3.0

QC1

INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEET

a.m 09.02.230

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA248

2- File transition lines smooth.

a.m 09.02.230

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-667-205 PAR #: \_\_\_\_\_ Fault Category: Prod/tube NCR: (Yes) No DQA: D Date: 05/04/03  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 05/04/03

NCR: <u>45893</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.02	2	CUFF ON SIDE 'A' IS 0.30" TO SHORT. END OF TAPER WAS RE-DONE BECAUSE OF TOOL BREAK. TOOL POSITIONED INCORRECTLY ON SECOND PASS	<u>Q</u> 08.03.02 per QSI 042	MACHINE SIDE 'B' CUFF TO MATCH SIDE 'A'.	<u>A.m</u>	<u>Q</u> 08.03.02 per QSI 042	<u>Q</u> 08.03.02 per QSI 042	<u>Q</u> 08.03.02 per QSI 042
09.03.23	2.0	TUBE WAS SCRAPED DUE TO Z ALIGN OFF BY 1.250" Set-up error L.C: lack of attention	<u>Q</u> 09.03.31 QSI 042	Scrap & destroy tube. 0.100" approx. deep marks near center on tube.	<u>MS</u> 09-03-31	<u>Q</u> 09.03.31	<u>Q</u> 09.03.31 QSI 042	<u>Q</u> 09.03.23
			<u>Q</u> 09.03.31 QSI 042	Retrain employee.	<u>A.m</u>		<u>Q</u> 09.03.31 QSI 042	

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 11:50:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 45893

Part Number: D407667205TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D407-667-245  
Inside of Cuff(Donot engrave on outside of tube)

Q-M 09.02.23 @

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Q-M 09.02.23 @

6.0

QC8

SECOND CHECK



**ENGINEERING  
APPROVAL**



(PTC)

Comment: SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1  
Ensure no sand is in the tube before alodine.

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock in kanban rack  
Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D907-667-205 PAR #: N/A Fault Category: Prod / x-tube NCR: (Yes) No DQA: A Date: 09/04/03  
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 09/04/03

NCR: <u>09-026</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-02	6.0	Upon the QCB inspection, it was noticed that the cuff dimension for I side was shorter, than what was recorded. Should be 4.978" is 4.670"	<u>[Signature]</u> 15/04/02	NCR 09-026 has been created	<u>A.m</u>	<u>[Signature]</u> 16/03/03	<u>[Signature]</u> 16/04/02	<u>09-03-02</u>

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> <u>45893</u>
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b> <u>D407-667-245</u>
<b>Inspection Dwg:</b> D407-667-245 <b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.493	✓		
	1.832	+0.005/-0.000	1.832	✓		
	1.838	+0.005/-0.000	1.843	✓		
	1.892	+0.005/-0.000	1.897	✓		
	2.052	+0.005/-0.000	2.054	✓		
	2.206	+0.005/-0.000	2.206	✓		
	2.521	+0.005/-0.000	2.526	✓		
	2.633	+0.005/-0.000	2.638	✓		
	4.10	+/-0.030	4.10	✓		
	4.978	+/-0.030	4.978	✓		NCR 09-026
	2.040	+0.000/-0.010	2.040	✓		
	0.125	+/-0.010	0.125	✓		
	R0.063	+/-0.010	R0.063	✓		
	R0.500	+/-0.010	R0.500	✓		
SIDE B	2.490	+0.005/-0.000	2.493	✓		
	1.832	+0.005/-0.000	1.832	✓		
	1.838	+0.005/-0.000	1.843	✓		
	1.892	+0.005/-0.000	1.897	✓		
	2.052	+0.005/-0.000	2.054	✓		
	2.206	+0.005/-0.000	2.206	✓		
	2.521	+0.005/-0.000	2.526	✓		
	2.633	+0.005/-0.000	2.638	✓		
	4.10	+/-0.030	4.10	✓		
	4.978	+/-0.030	4.978	✓		
	2.040	+0.000/-0.010	2.040	✓		
	0.125	+/-0.010	0.125	✓		
	R0.063	+/-0.010	R0.063	✓		
	R0.500	+/-0.010	R0.500	✓		
	112.906	+/-0.020	112.900	✓		

<b>Measured by:</b> <u>Q. M.</u>	<b>Audited by:</b> _____	<b>Prototype Approval:</b> _____	N/A
<b>Date:</b> <u>09.02.23</u>	<b>Date:</b> _____	<b>Date:</b> _____	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-205)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	06.03.30	Tolerance revised for 4.978 dimension	KJ/JLM	
D	07.02.19	Dwg Rev updated	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.  
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
08/11/06

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F. REMOVE -B51 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. F
CHECKED	RF	D407-667-245	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (407 HIGH AFT)	NTS
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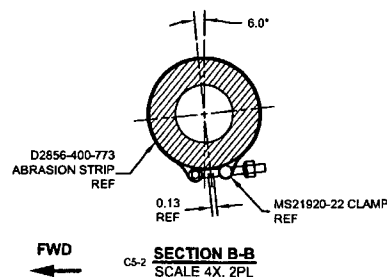
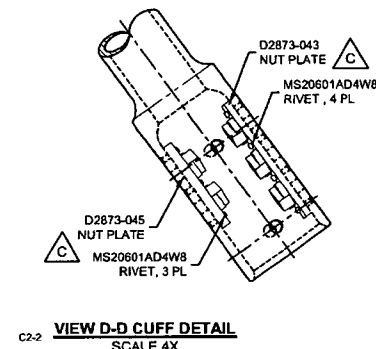
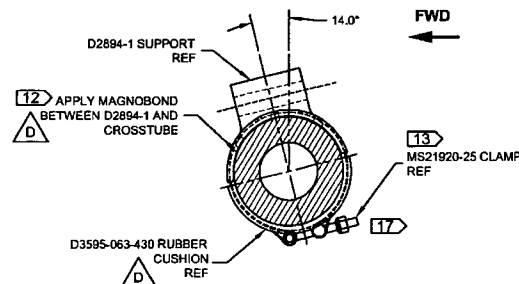
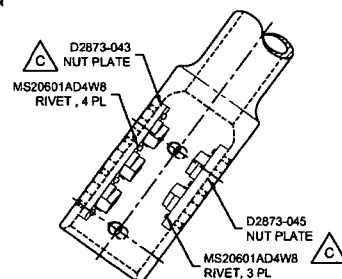
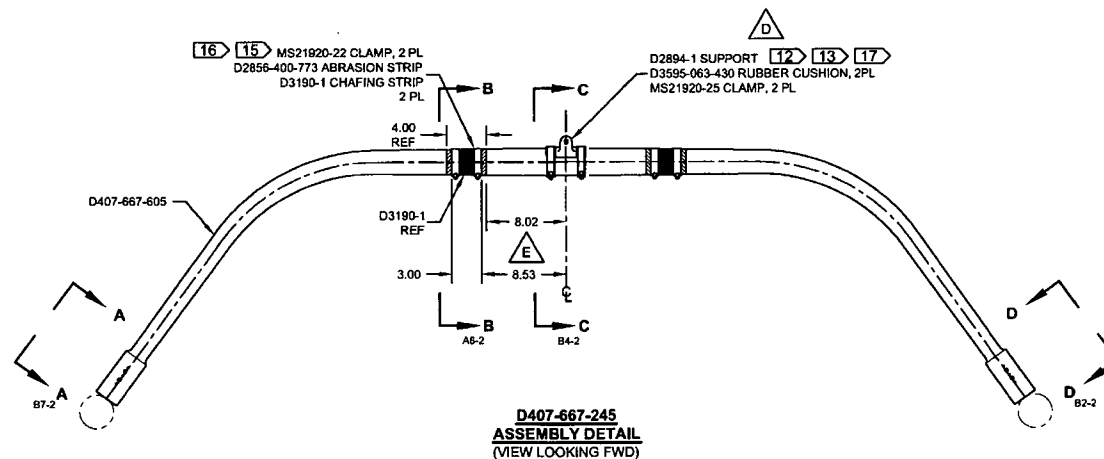
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	JP	DRAWING NO.	REV. F
MFG. APPR.	JP	D407-667-245	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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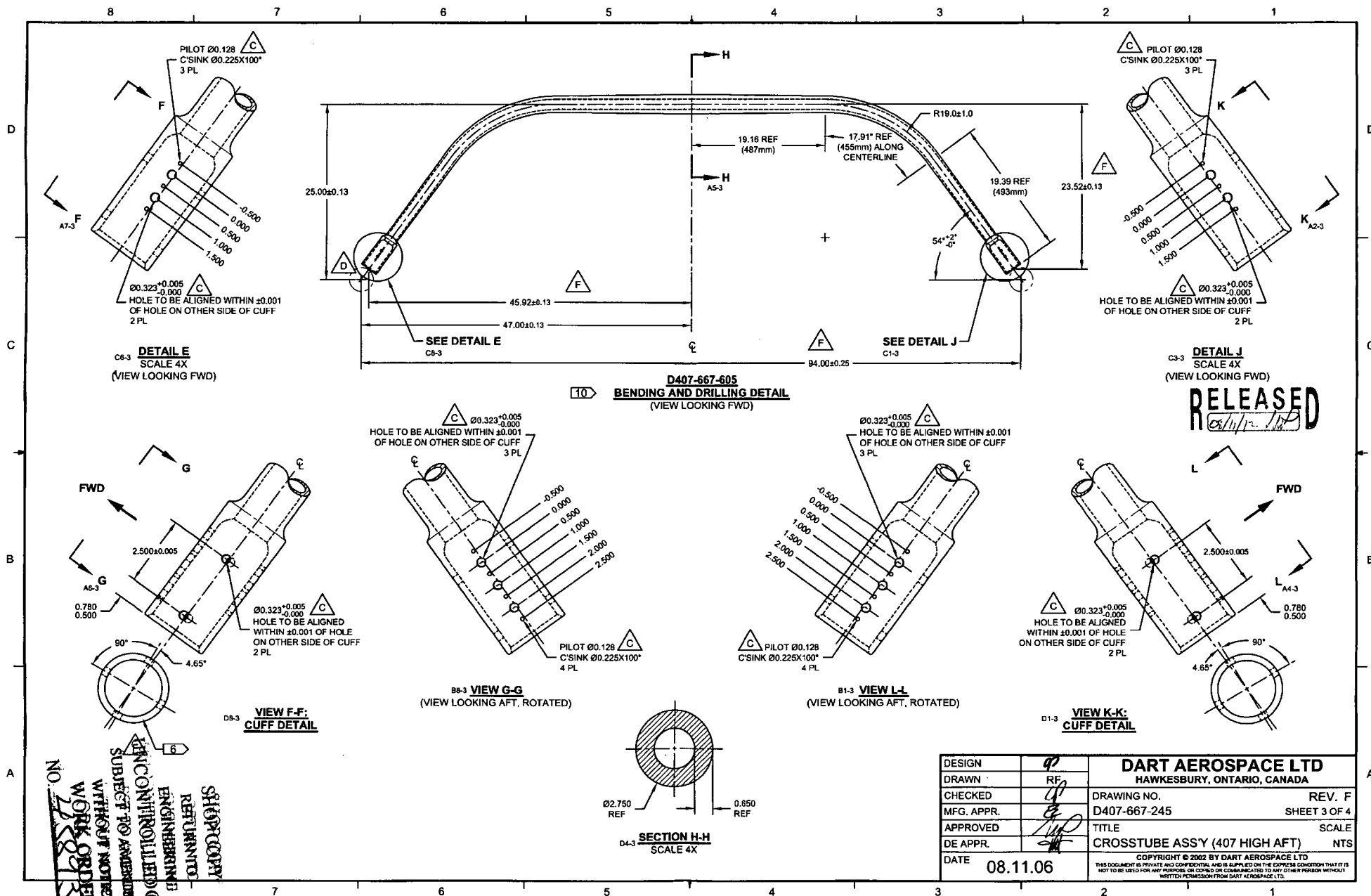
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DESIGN	40	DART AEROSPACE LTD	
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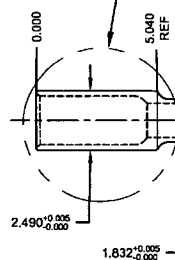
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

SEE DETAIL M  
A7-4



R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

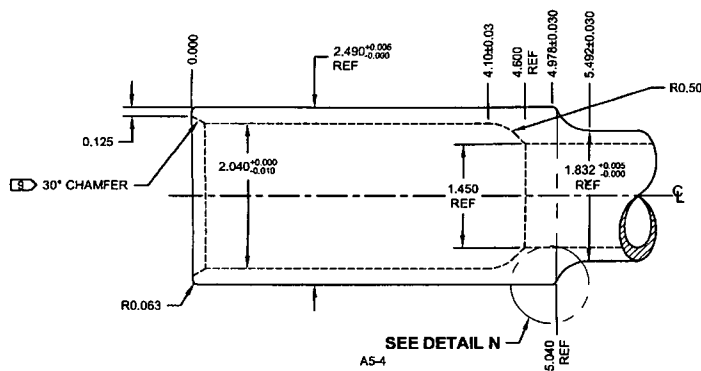
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BETWEEN TAPERED  
SECTIONS

SEE DETAIL P  
A2-4

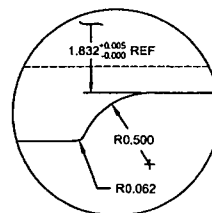
TAPER UNIFORMLY FROM  
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RUNNING OFF PART

RELEASED  
08/11/12

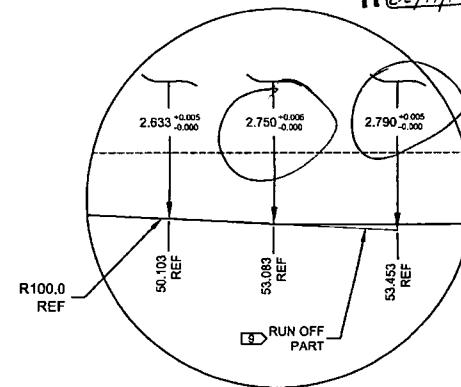
**D407-667-245 MACHINING DETAIL**



SEE DETAIL N  
A5-4



**DETAIL N: CUFF TRANSITION**  
SCALE 2X



**DETAIL P: TAPER RUN-OFF**  
NOT TO SCALE

**DETAIL M: CROSSTUBE CUFF**  
SCALE 3X

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NO. 45893

DESIGN	90
DRAWN	RF
CHECKED	CP
MFG. APPR.	JP
APPROVED	JP
DE APPR.	JP
DATE	08.11.06

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D407-667-245 REV. F  
SHEET 4 OF 4  
TITLE CROSSTUBE ASSY (407 HIGH AFT) SCALE NTS

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries